Work Orden June-12-13 9:23:		2989			Page 1								
Revision ID:	D3161-7 Hinge 14.0"			Accept	*N900	040	100)*	Setup	Start Stop	i VI	S1*,	
Start Date: 6	5/11/13	Start Qty: 8.00	*8*		Cust Item 1	ID:							
Required Date: 6	5/11/13	Req'd Qty: 8.00	*8*		Customer:								
Reference:	•		.,										
Approvals:	Process Pla	an: MF.	Date: \3-6-13	Tooling:	D	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re		Reject Number	Insp. Stamp	
Draw Nbr	Re	vision Nbr					*						
D3161	Rev	v A2										0	_
100		Small Fab		0.00				8x				1/5	36:
Small Fab		Memo		0.00				- <i>O</i>					/ /
Small Fab		(1) 72" Hin D3161	ge makes (5) D3161-7 parts	at 14" longCut to length	n as per Dwg								*
110		QC5- Inspect part comp	leteness to step on W/O	0.00	, 1				_			1	
*11 0 *		TAD + como	(Stan Do Not s	0.00	izlorles			(48) _				
Quality Control		on part	(Stan Don's	stuck)									
120		Identify as per dwg & St	tock Location: 5703	0.00				8					
120 Packaging Packaging		Memo		0.00				<u> </u>				13-07-	05

DQA:			Date:						_				TAART
			ъ.			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD				AEROSPACE
QA Closed:			Date:							V	ork Order up	date only	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	_		 		_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap			 	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is			noforming	Finishing	⊣	re/Packaging	Other
NCR No.						⊢ •			- 	Composite		Supplier	
Root		-			Desci	ription of work order update	ı	Initial	Action	1	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	QC Inspector
Design			,										
Doc/Data									1				
Equip/Tooling						:							
Handling/Pre		-											
Material													
Operator													
Offset/Setup	Ц												
Process													
Supplier	Ш	-											
Training													
Transport													
Unapproved													
						· · · · · · · · · · · · · · · · · ·	FA		TEGORY				
Landi						General		34		_	- -		7
	\vdash	ending				Bend	_	1	Program	<u> </u>	Outside Dim	 	Pressure/Forced
		entre No	t Concer	ntric	-	BOM/Route		Grain		_	Over/Under		Set-up
		racks			<u> </u>	Broken/Damage/Defect		Hardwa		_	Part Incorred	 	Temperature/Cure
	\vdash	Crimp/Kink/Ripple/Wave			<u> </u>	Burrs		1	ion Incomplete/Unqu	-	Part Lost/Mi	- ⊢	Weld
	\vdash	Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/Unc	lear	Part Moved	يسا	Wrong Stock Pulled
		rushing			<u> </u>	Countersink	<u> </u>	1 '	gned/off center	_	Positioned V		ا ا
	Heat Treat				<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other
	Inspection Strip in Tube			Tube	<u> </u>	Drawing	_	Misrea				- 	
	\vdash	/larks/Ch			<u> </u>	Drill Holes	<u> </u>	Off-set					
;	-	urning Se			<u> </u>	Finish	_	-1	Calibration				
	Wave/Twist in Tube					Fit/Function		Out of:	Sequence				

Work Ord June-12-13 9:		2989		*102989*										
Item ID: Revision ID: Item Name:	D3161-7 Hinge 14.0"		*N900040100* Setup Sta									S1* S2*		
Start Date: Required Date Reference:	6/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID: Customer:						1 4			
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate: ate:		J	Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	•	
130		Memo		0.00						2/7	1/8	- H		

Quality Control

13-7-5

DQA:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:		Date:			WORK ORDER NON	-C(JNFO	RIMANCE / UPD		Wc	ork Order up	date only		AEROSPACE	
Work Orde	r:				DISPOSITION				AGAINST	DE	PARTMENT	PROCESS			
WORK OTGE					Rework	1		Skid-tube	\neg	Water Jet			Engineering		
Part N	0.				Scrap	1		—	Crosstube Small Fab	\dashv	Pro	d. Eng. Coor.	\dashv	Quality	
					Use-as-is	1		noforming	Finishing	\dashv		e/Packaging	\dashv	Other	
NCR No.					Suspected Unapproved			Large Fab Composite			Supplier				
Root				Desci	ription of work order update		nitial	Action	· 		Sign &				
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	ion		Date	Verification	1	QC Inspector	
Design															
Doc/Data															
Equip/Tooling														•	
Handling/Pre															
Material	_														
Operator															
Offset/Setup	_					•									
Process	_										:				
Supplier															
Training	4														
Transport		İ													
Unapproved			1	<u> </u>											
				_		FAI	ULI CA	TEGORY							
Landin	ng Gear	_			General]		Г		la a.	. г			
}	Bendin	•		-	Bend BOM/Bouto	\vdash	4	Program	-		Outside Dim	- F	\dashv	Pressure/Forced	
}		Not Conce	ntric	-	BOM/Route	-	Grain		}		Over/Under	-	\dashv	Set-up	
}	Crimp	Vink/Dinnk	- /\Alaua	-	Broken/Damage/Defect	\vdash	Hardwa		_1:6:	-	Part Incorred	- F	\dashv	Temperature/Cure	
}	Crimp/Kink/Ripple/Wave			\vdash	Burrs	-	1 '	ion Incomplete/Unqu	+	\rightarrow	Part Lost/Mi	- I		Weld	
}	Crushing			-	Contamination Countersink	-	4	tions Incomplete/Unc	iear	_	Part Moved]	Wrong Stock Pulled	
}	Crushing Heat Treat		-	Cut Too Short	\vdash	Mislabe	gned/off center			Positioned V		\neg	Othor		
-		reat tion Strip in	Tuho	\vdash	Drawing	-	Misrea		L		Power Loss/	ourge [Other	
			ilube		Drill Holes	\vdash	Off-set								
	Marks/Chatter				Finish	\vdash	-	Calibration							
 	Turning Sequence Wave/Twist in Tube				Fit/Function	\vdash	→	Calibration							

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

June-12-13 9:23:50 AM

Work Order ID:

102989

Parent Item:

D3161-7

Parent Item Name:

Hinge 14.0"

Start Date: 6/11/13

Required Date: 6/11/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP A04.08.24New IssueKJ/JLM

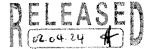
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200 Piano Hinge		Purchased	No	,		100	f	70.3753	1,2	9.6	JS.	3/0	7/4
_				Location		Loc Qty	<u>Lo</u>	c Code			•		
				ST209a		70.3752628							
				1239	960	6.4552628			-				
				1254	145	63.92			4	6_			

DQA:	 , .		Date:													
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / U	JPDATE	١٨/.	ork Order up	ndata only	A E R O S P A	CE	
QA Closeu.		,	Date.				_				VV	ork Order up	date only			
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		i	
						Rework	1	1	Skid-tube	Crosstube			Water Jet	Engineering	7 I	
Part N	No.					Scrap	1 1	Machining Small Fab				Pro	d. Eng. Coor.	Quality	7]	
	_					Use-as-is	1	1	noforming	Finishing		4	re/Packaging	Other	7 1	
NCR No.						Suspected Unapproved			Large Fab	Composite			Supplier			
Root Des					Desc	ription of work order update	der update Initial Action S				Sign 9		<u> </u>			
Cause		ate	Step	Qty	Desci	or non-conformance		nief Eng	•	cription		Sign & Date	Verification	OCInchesto		
Design		ate	Step	Qty		or non-comormance	CII	ilei ciig	Desc	ription	-	Date	verification	QC Inspecto	-	
Doc/Data	H															
Equip/Tooling													-			
Handling/Pre	H															
Material							l						:			
Operator																
Offset/Setup	Н	l														
Process							1									
Supplier		Ì		,												
Training		ł														
Transport																
Unapproved		-														
							FA	ULT CAT	EGORY			*				
Landi	ng Gear	•				General						·				
	Ber	nding				Bend		Folio/P	rogram			Outside Dim	ensions	Pressure/Forced		
	Cer	itre No	t Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up		
	Cra	cks				Broken/Damage/Defect] Hardwa	re			Part Incorred	ct [Temperature/Cu	re	
	Crimp/Kink/Ripple/Wave				Burrs		Inspecti	on Incomplete/L	Jnqualified		Part Lost/Mi	ssing	Weld			
	Cuffs				Contamination		Instruct	ions Incomplete/	/Unclear		Part Moved		Wrong Stock Pull	ed		
	Cru	shing				Countersink		Misalig	ned/off center			Positioned V	Vrong			
	Heat Treat			ļ	Cut Too Short		Mislabe	led			Power Loss/	Surge	Other			
	Ins _I	pection	Strip in	Tube		Drawing .		Misread	i							
	<u></u> Ма	rks/Cha	atter			Drill Holes		Off-set								
	Turning Sequence				Finish		Out of 0	Calibration								
Wave/Twist in Tube				Fit/Function	1	Out of S	enuence									





DESIG	#	DRAWN		OSPACE LTD ONTARIO, CANADA
CHEC	KED KF	APPROVED	DRAWING NO.	REV. A SHEET OF
DATE	02.04	.24	TITLE HINGE	SCALE NTS
 Α	02	.04.24	NEW ISSUE	



***************************************		02.04.24	HINGE NTS
	Α	02.04.24	NEW ISSUE
-	ΑI		4DDED D3161-5
	<u>A2</u>	J. # 04.06 30	A00 03161-7 & 03161-9

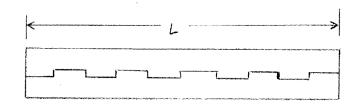
P/N	LENGTH 'L'
D3161-1	13.5"
D3161-3	15.0"
D3161-5	4.9"
03161-7	14.00
2344	17.6"

DESCRIPTION HINGE (REPLACES MS 20257-3-13.5 ON DZ183)

HINGE (REPLACES MS 20257-3-150 ON D2950-041)

HINGE HINGE

HINGE



NOTES:

1) MAKE FROM MS20257 - 3-7200 HINGE



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DQA:		_ Date:										DA DT
		_			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			-	AEROSPACE
QA Closed:		Date:					·		W	ork Order up	odate only	
Work Orde	er:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS	
					Rework			Skid-tube Crosstube]	Water Jet	Engineering
Part N	lo.				Scrap		(Machining Small Fab	,	Pro	d. Eng. Coor.	Quality
					Use-as-is		Thern	noforming Finishing	,	Rec/Sto	re/Packaging	Other
NCR N	lo				Suspected Unapproved			Large Fab Composite]		
Root				Desci	ription of work order update	- !	nitial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data												
Equip/Tooling												
Handling/Pre												
Material												
Operator												
Offset/Setup												
Process												
Supplier												
Training												
Transport												
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	Bending			<u> </u>	Bend	<u> </u>	4	rogram	<u> </u>	Outside Dim		Pressure/Forced
		lot Conce	ntric	<u> </u>	BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under		Set-up
	Cracks				Broken/Damage/Defect	ļ	Hardwa		_	Part Incorred) —	Temperature/Cure
!	Crimp/Kink/Ripple/Wave				Burrs		1 `	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	- 	Weld
	Cuffs				Contamination	<u> </u>	4	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink	<u> </u>	-	ned/off center	\vdash	Positioned V		, l
	Heat Treat			Cut Too Short		Mislabe			Power Loss/	Surge	Other	
					Drawing	_	Misread					
			Drill Holes	<u> </u>	Off-set							
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